

Date: Wednesday, 9/12/2007 12:13:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 34596		
Estimate Number	: 10613		
P.O. Number	: <i>N/A</i>	Part Number	: D265615
This Issue	: 9/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 34170	Material	: <i>N/A</i>
		Due Date	: 9/30/2007
Written By	:	Qty:	<i>40</i> Um: Each
Checked & Approved By	:		
Comment	: Est: D 02.10.25 Re-format KJ		
	: Est Rev:E Now on Waterjet 06-09-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.6431 sf(s)/Unit Total : 12.8625 sf(s)
 1010/1025/A21/6aA SHEET (.040")
 (M1010S20GA)
 Batch: *M105671 B07-09-24*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: *D B07-09-24*
 Prog Rev: *D*
 2-Deburr if necessary *B07-09-24*

(40)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

B07-09-24

on 07/09/25

(40) counter

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158
 3-Identify as D2656-15

SP 07/09/25 (40) 4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/09/20 ^{2/10/20}

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:12 PM
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Process Sheet

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Drawing Name: WEARSHOE

Job Number: 34596

Part Number: D265615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

En 07/09/25

(440)

7.0

POWDER COATING

POWDER COATING



m/104846

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL

07/09/26

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

elb

04-01-24

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-16

FL

07/09/27

(40)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

FL 07/09/28

Job Completion



W 07-09-28

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 34596
Description: Wearshoe		Part Number: D2656-15
Inspection Dwg: D2656	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.150	+/-0.010	39.150	/			
35.650	+/-0.010	35.650	/			
33.650	+/-0.010	33.650	/			
30.150	+/-0.010	30.150	/			
24.900	+/-0.010	24.900	/			
19.650	+/-0.010	19.650	/			
14.400	+/-0.010	14.400	/			
9.150	+/-0.010	9.150	/			
5.650	+/-0.010	5.650	/			
2.000	+/-0.010	2.000	/			
1.885	+/-0.010	1.89	/			
0.300	+/-0.010	.299	/			
0.300	+/-0.010	.299	/			
0.040	+/-0.010	.047	/			

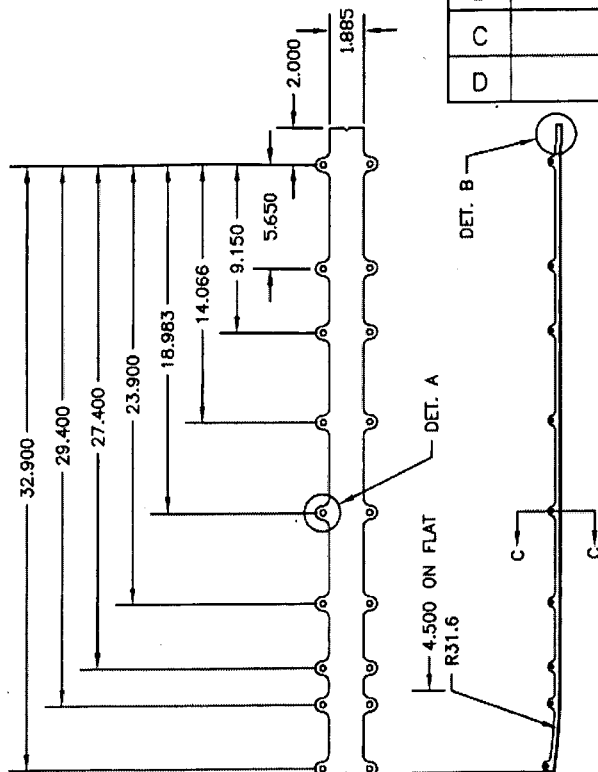
Measured by: IB	Audited by: ES	Prototype Approval:	N/A
Date: 07-09-24	Date: 07/09/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

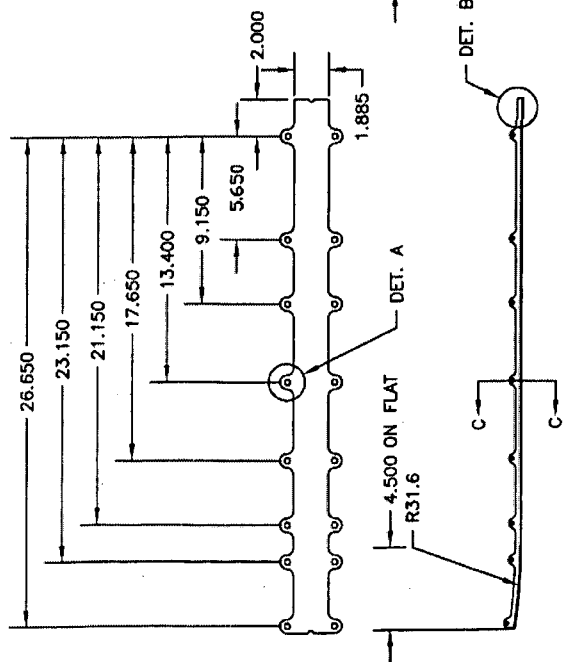


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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

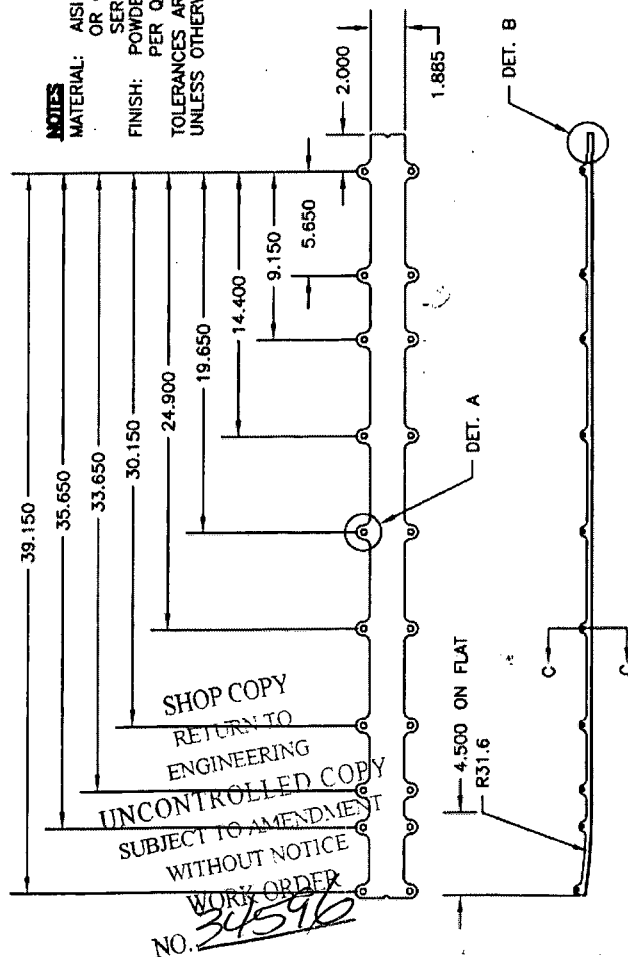
D2656-13



D2656-11



D2656-15



NOTES
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA G40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

RELEASED
 05.09.08

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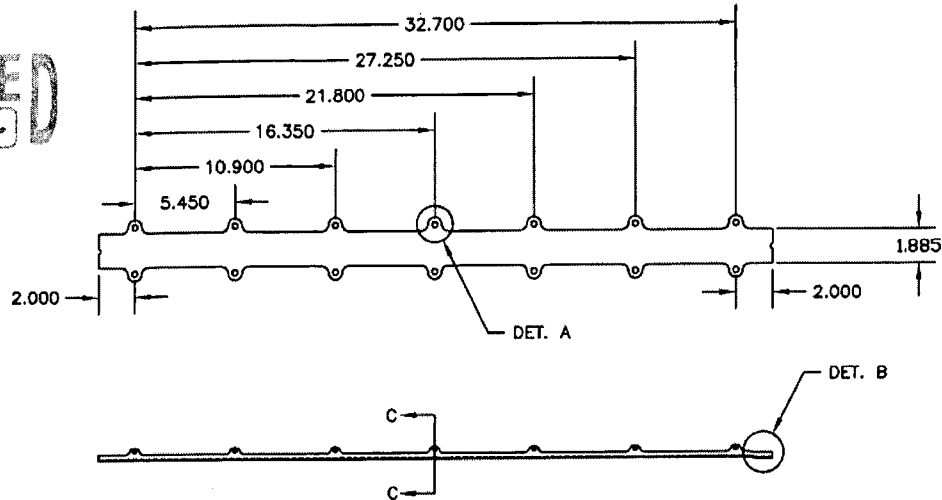
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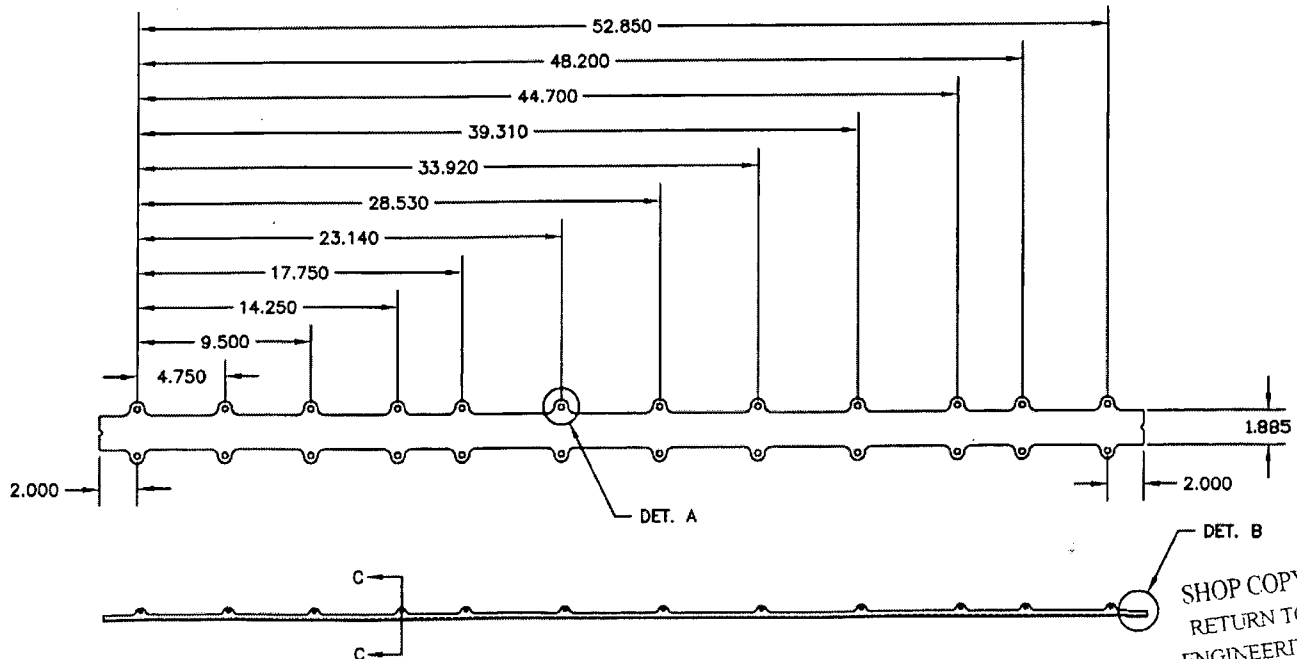
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				D2656	SHEET 2 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10

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D2656-21



D2656-23



NOTES

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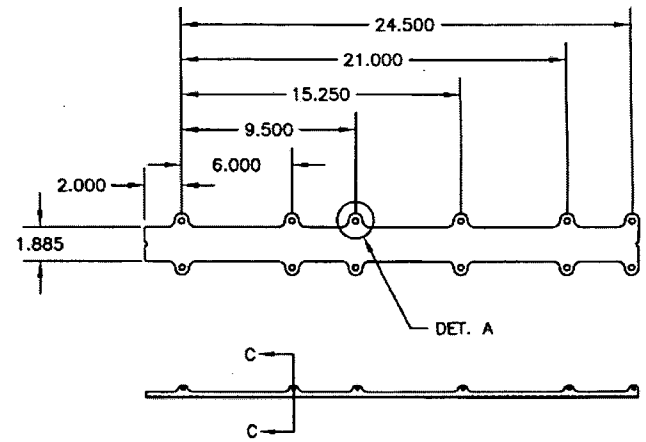
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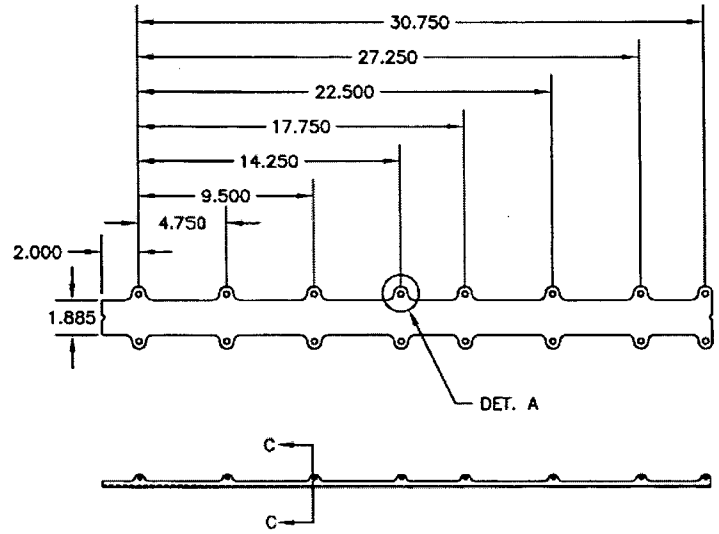


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DATE	05.08.17	DRAWING NO.	D2656	TITLE	WEARSHOE
				SCALE	1:10

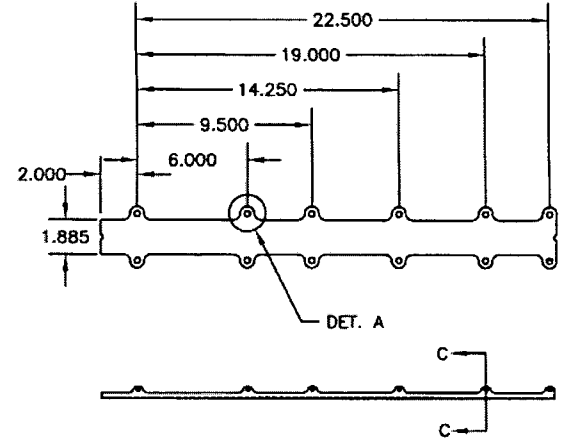
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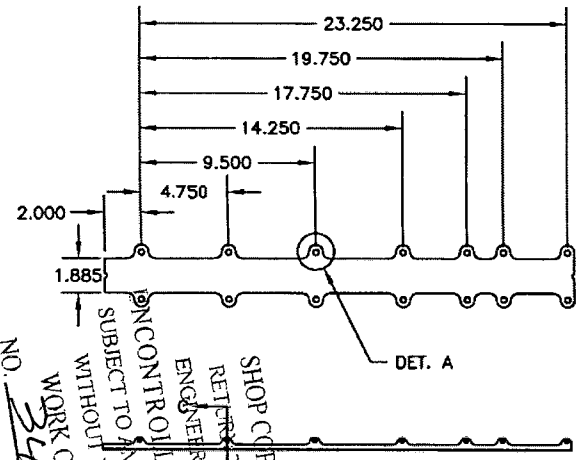
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D2656-31



D2656-35



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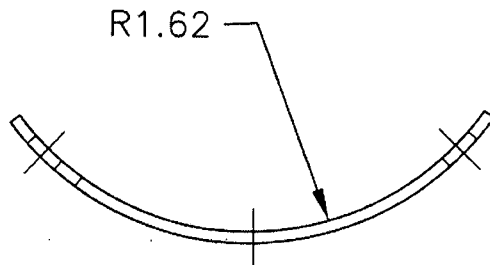
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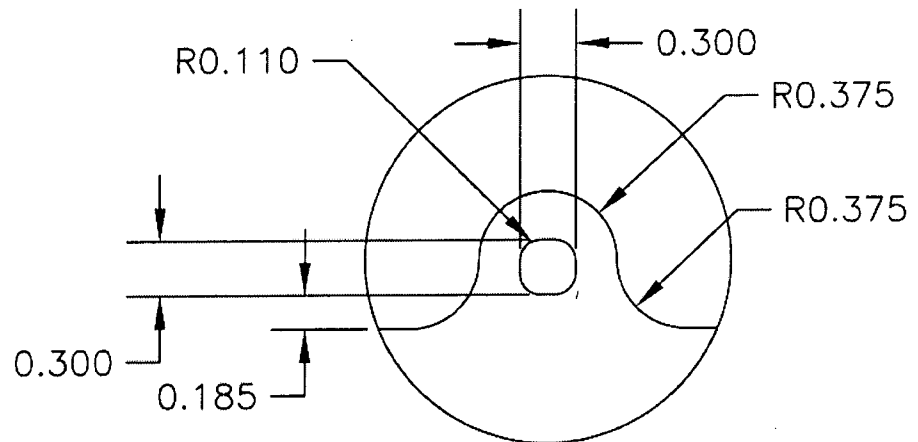
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

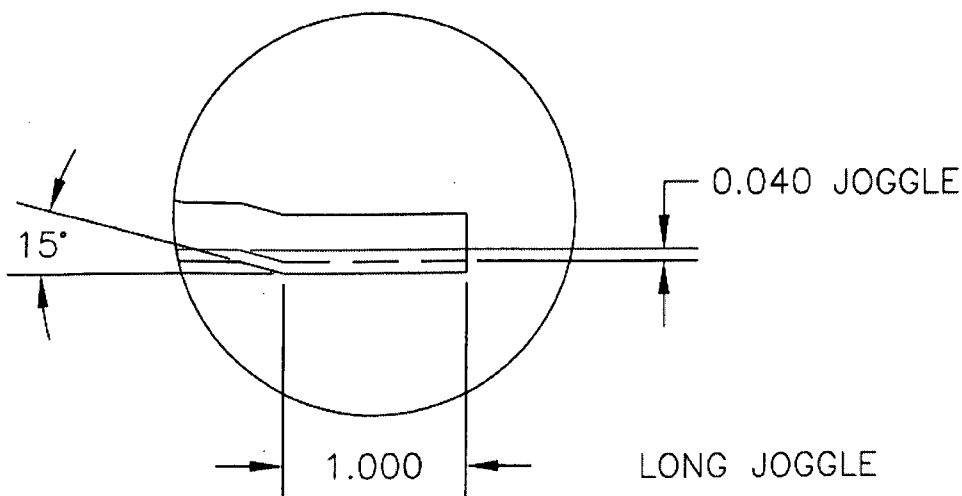


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DETAIL B



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